


539

DART AEROSPACE LTD	Work Order:	24176
Description: Doubler	Part Number:	D2913
Drawing: D2913 Rev. XB	Qty:	X 12

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	JP	05/09/06	4
2	METAL	Cut blanks: 3.430" x 1.900" \pm 0.005" Material: 2024-T3 (QQ-A-250) 0.080 Thick Batch M17400	BC	05-09-26	12
3	HAAS	Machine as per Folio D2913	BC	05-09-26	12
4	QC	Inspect Level 2	BC	05-09-26	12
5	METAL	Deburr	SAD	05/10/01	12
6	METAL	Countersink as per Dwg D2913	SAD	05/11/17	12
7	METAL	Bend as per Dwg D2913	SB	05/11/21	12
8	METAL	Acid etch and alodine as per QSI 005 4.1	SAD	05/11/27	12
9	QC	Inspect Level 5	J	05-11-28	12
10	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3	a.m	06-02-20	12
11	QC	Inspect Level 3	FL	06/02/20	12
12	STORES	Identify and stock	U	6/2/21	12
13	EXPEDITING	Close W/O Cost / part: <u>5439</u> <u>545 06/02/22</u> <u>12</u>	LS	06/02/22	12

Rev	Date	Change	Revised By	Approved
A	99.09.20	New Issue	EC	
B	99.10.19	Now goes on Haas	EC	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED

 JUN 26 2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 9 Date: 06/02/22

NOTE: Date & initial all entries

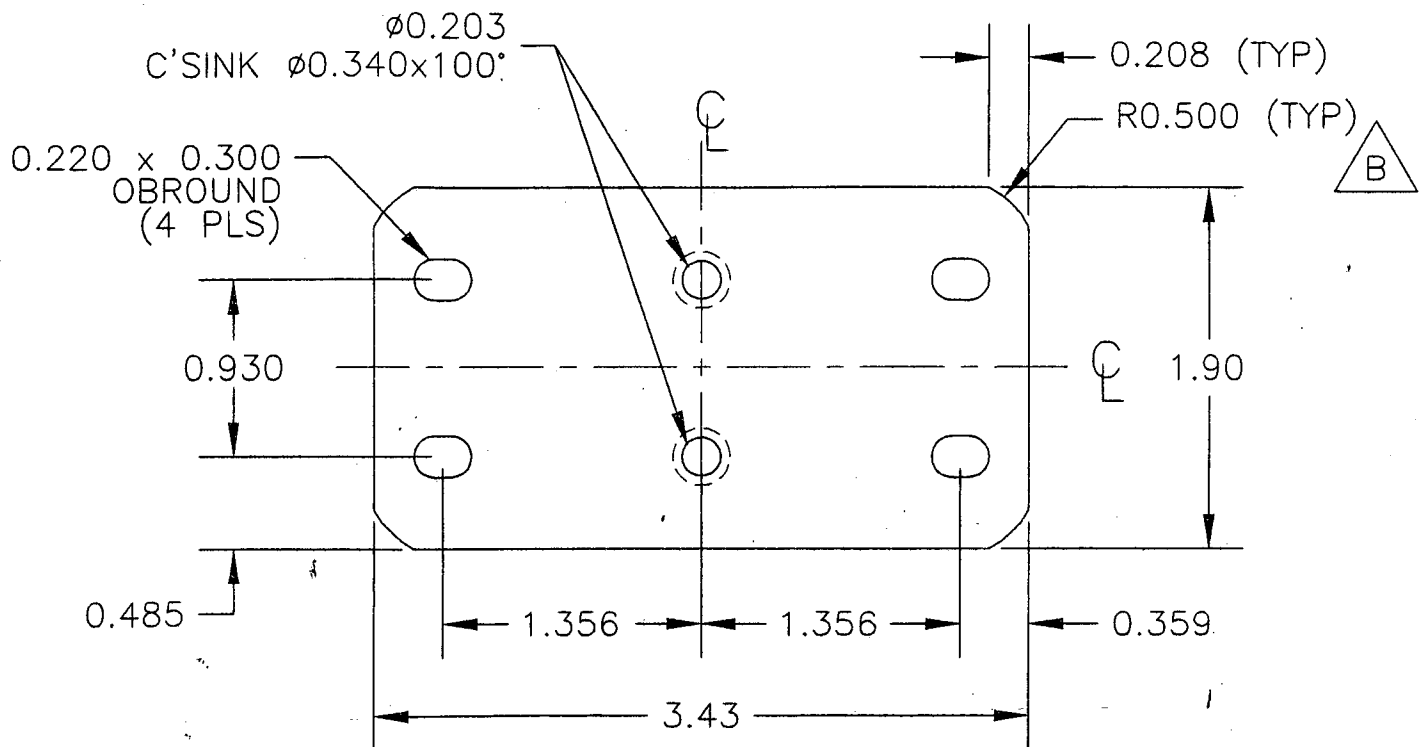
QA: N/C Closed: _____ Date: _____



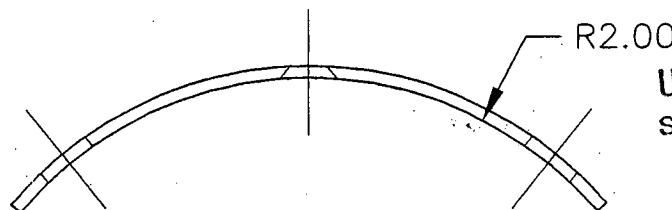
DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D2913	REV. B SHEET 1 OF 1
DATE 99.10.18		TITLE DOUBLER	SCALE 1:1
A	99.10.07	NEW ISSUE	
B	99.10.18	ADDED RADIUS	

RELEASED
99.10.19 DS

FLAT PATTERN



BEND DETAIL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 24176

MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11)
0.080 THICK

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL SHARP EDGES 0.010 TO 0.020

0.

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 01, 2005
10:49 am

Work Order No : 0024176
Project Name : D2913
Project For : DOUBLER WK539
Work Order Type : Main
Main WO Number :
House Part Number : D2913
Description : Doubler
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 08-31-05
Est Finish Date : 09-29-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

